

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005123**Date Inspected:** 05-Jan-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu You Saen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Assembly**Summary of Items Observed:**

On this date CALTRANS OSM Quality Assurance (QA) Inspector was present during the times noted above for observations relative to the work being performed.

Segment Repair Yard (North of Bay 14)

Segment 5BW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld#SEG023A-031 for the side panel to corner assembly plating splice welds. The welder is identified as #067609. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM.

Flux Cored Arc Welding (FCAW) in the 2G position of weld#SSD13-PP32-127 for the floor beam flange splice weld at panel point 32. The welder is identified as #201215. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

Shielded Metal Arc Welding (SMAW) in the 3G position of weld#SEG023E-127 for the deck panel transverse stiffener in way of the crossbeam. The welder is identified as #067656. ZPMC QC is identified as Mr. Wu Shi Gao.

The welding variables recorded by QC appeared to comply with WPS-B-P-2213-TC-U46-FCM.

Segment 5AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld#SEG021A-004 for the side panel to bottom panel plating splice welds. The welder is identified as #061829. ZPMC QC is identified as Mr. Wu Shi Gao. The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2-FCM.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

Segment Repair Yard (North of the Paint Shop)

Segment 3AW

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld#SEG013-031 for the deck panel to corner assembly repair welds. The welder is identified as #047864. ZPMC QC is identified as Mr. Fu You Saen. The welding variables recorded by QC appeared to comply with WPS-345-SMAW-4G(4F)-Repair.

The grit blasting and surface preparation for painting on the diagonal trusses at all panel points.

Segment 3BW

This QA Inspector observed the following work in progress:

The carbon arc gouging of defects found in the side panel SP10A to Corner assembly CA3A splice weld.

Unless otherwise noted, all work observed on this date appeared to generally comply with the applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, (+86) 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
